

Date: Thursday, 31/07/2008 1:30:56 PM
User: Julie Lecoq

Process Sheet

Split

Customer : CU-DAR001 Dart Helicopters Services
Job Number : 40859-1
Estimate Number : 10738
P.O. Number :
This Issue : 31/07/2008 S.O. No. :
Prsht Rev. : NC
First Issue : 31/07/2008 Type : SMALL /MED FAB
Previous Run : 40186
Written By :
Checked & Approved By : JLD 08.8.01
Comment : Est: B 04.10.05 Revised Step 5 with headrest identification K
J/JLM

Drawing Name : HEAD REST
Part Number : D3303041
Drawing Number : D3303 REV.B
Project Number : N/A
Drawing Revision : B
Material :
Due Date : 08/08/2008 Qty: 20 Um: Each

13
~~13~~

Additional Product

Job Number:



Seq. #: Machine Or Operation: Description :

1.0 D3303043 Bracket Assembly



Comment: Qty.: 1.0000 Each(s)/Unit Total : 26.0000 Each(s)

BRACKET ASSEMBLY

Pick:

Qty	Part Number	Description	Batch
1	D3303-043	Bracket Assembly	41199 B 41200 B 41650

7
6

SA 09/02/13

13

2.0 D33051 Cushion



Comment: Qty.: 1.0000 Each(s)/Unit Total : 26.0000 Each(s)

FOAM CUSHION

Pick:

Qty	Part Number	Description	Batch
1	D3305-1	Cushion	B 41200

8

SA 09/02/13

13

3.0 D3306041 Cover Assembly



Comment: Qty.: 1.0000 Each(s)/Unit Total : 26.0000 Each(s)

COVER ASSEMBLY

Pick:

Qty	Part Number	Description	Batch
1	D3306-041	Cover Assembly	B 41247 B 42167 B 40910

9
10

SA 09/02/13

13

W/O:		WORK ORDER CHANGES					
DATE	STEP	PROCEDURE CHANGE	By	Date	Qty	Approval Chief Eng / Prod Mgr	Approval QC Inspector

Part No: _____ PAR #: _____ Fault Category: _____ NCR: Yes No DQA: _____ Date: _____

QA: N/C Closed: _____ Date: _____

NCR:		WORK ORDER NON-CONFORMANCE (NCR)						
DATE	STEP	Description of NC Section A	Corrective Action Section B			Verification Section C	Approval Chief Eng	Approval QC Inspector
			Initial Chief Eng	Action Description Chief Eng	Sign & Date			

NOTE: Date & initial all entries

Date: Thursday, 31/07/2008 1:30:56 PM
User: Julie Lecocq

Process Sheet

Customer: CU-DAR001 Dart Helicopters Services

Drawing Name: HEAD REST

Job Number: 40859

Part Number: D3303041

Job Number:



Seq. #:

Machine Or Operation:

Description :

4.0

SMALL FAB 1

SMALL & MEDIUM FAB RESOURCE 1



Comment: SMALL & MEDIUM FAB RESOURCE 1

1- Bond foam to D3303-043 bracket assembly as per Dwg D3303 using 3M 1300/1300L or 8046 adhesive.
Identify as D3303-041

A/R 3M 1300/1300L Adhesive Batch: M1109410

2- Cover Head Rest with D3306-041 as per Dwg D3303

SD
09/02/13 (13)

5.0

QC5

INSPECT WORK TO CURRENT STEP



Comment: INSPECT WORK TO CURRENT STEP

09-02-13 (13)

6.0

PACKAGING 1

PACKAGING RESOURCE #1



Comment: PACKAGING RESOURCE #1

Identify with P/N and B/N, also identify the back of the headrest with TCCA-PDA # PDA04-11 using a permanent fine point marker as per Dwg D3303, then Stock

Location: 188

09/2/13

(13)

SD

7.0

QC21

FINAL INSPECTION/W/O RELEASE



Comment: FINAL INSPECTION/W/O RELEASE

09/02/17

Job Completion



mf
09-02-17

W/O:		WORK ORDER CHANGES					
DATE	STEP	PROCEDURE CHANGE	By	Date	Qty	Approval Chief Eng / Prod Mgr	Approval QC Inspector

Part No: _____ PAR #: _____ Fault Category: _____ NCR: Yes No DQA: _____ Date: _____

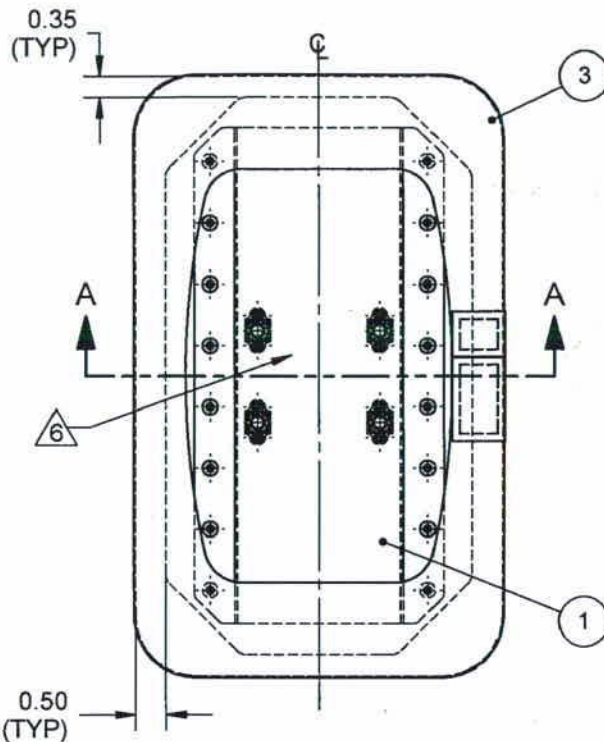
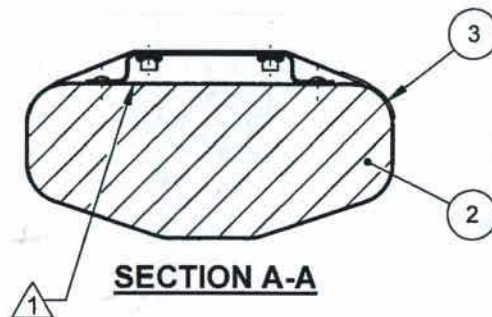
QA: N/C Closed: _____ Date: _____

NCR:		WORK ORDER NON-CONFORMANCE (NCR)						
DATE	STEP	Description of NC Section A	Corrective Action Section B			Verification Section C	Approval Chief Eng	Approval QC Inspector
			Initial Chief Eng	Action Description Chief Eng	Sign & Date			

NOTE: Date & initial all entries

DART

DESIGN <i>[Signature]</i>	DRAWN BY <i>[Signature]</i>	DART AEROSPACE LTD HAWKESBURY, ONTARIO, CANADA	
CHECKED <i>PH</i>	APPROVED <i>[Signature]</i>	DRAWING NO. D3303	REV. B SHEET 1 OF 4
DATE 06.08.17	TITLE HEAD REST SCALE 1:3		
REV A	DATE 04.08.18	DESCRIPTION NEW ISSUE	
B	06.08.17	UPDATED FLAT PATTERN TO FORM PART IN ONE OPERATION USING OFFSET DIE	

**RELEASED***dc 09.19***D3303-041 HEAD REST**

ITEM	QTY -041	P/N	DESCRIPTION
	X	D3303-041	HEAD REST
1	1	D3303-043	BRACKET ASSEMBLY
2	1	D3305-1	FOAM
3	1	D3306-041	COVER ASSEMBLY

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WORK ORDER
NO. *40859*

NOTES:

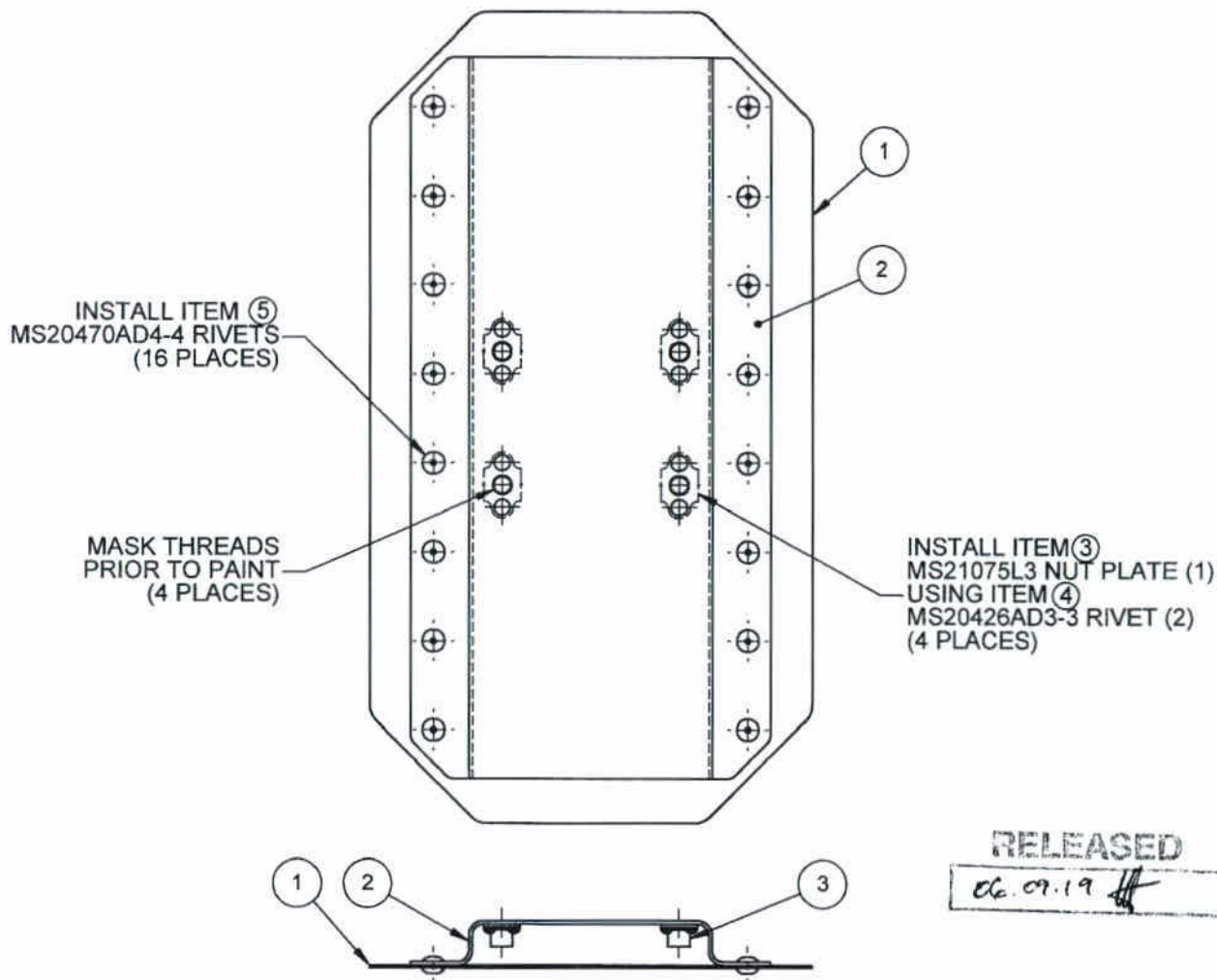
- 1) BOND D3305-1 FOAM TO D3303-043 BRACKET ASSEMBLY USING 3M 1300 ADHESIVE (0.002" TO 0.010" THICK) IN ACORDDANCE WITH MANUFACTURER'S INSTRUCTIONS
- 2) COVER HEAD REST WITH D3306-041 COVER ASSEMBLY AS SHOWN
- 3) PART IS SYMMETRICAL AT CENTERLINE
- 4) TOLERANCES ARE PER DART QSI 018 UNLESS OTHERWISE NOTED
- 5) ALL DIMENSIONS ARE IN INCHES UNLESS OTHERWISE NOTED
- 6) IDENTIFY AS FOLLOWS USING FINE POINT PERMANENT INK MARKER:
"TCCA-PDA, DART AEROSPACE LTD, P/N D3303-041 B/N BXXXXX, FOR PRODUCT ELIGIBILITY SEE PDA04-11"

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CHECKED <i>PH</i>	APPROVED <i>[Signature]</i>	DRAWING NO. D3303	REV. B SHEET 2 OF 4
DATE 06.08.17		TITLE HEAD REST	SCALE 1:2



RELEASED
06.09.19 *[Signature]*

D3303-043 BRACKET ASSEMBLY

ITEM	QTY -043	P/N	DESCRIPTION
	X	D3303-043	BRACKET ASSEMBLY
1	1	D3303-1	PLATE
2	1	D3303-3	HEAD REST
3	4	MS21075L3	NUT PLATE
4	8	MS20426AD3-3	RIVET
5	16	MS20470AD4-4	RIVET

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NO. 40859

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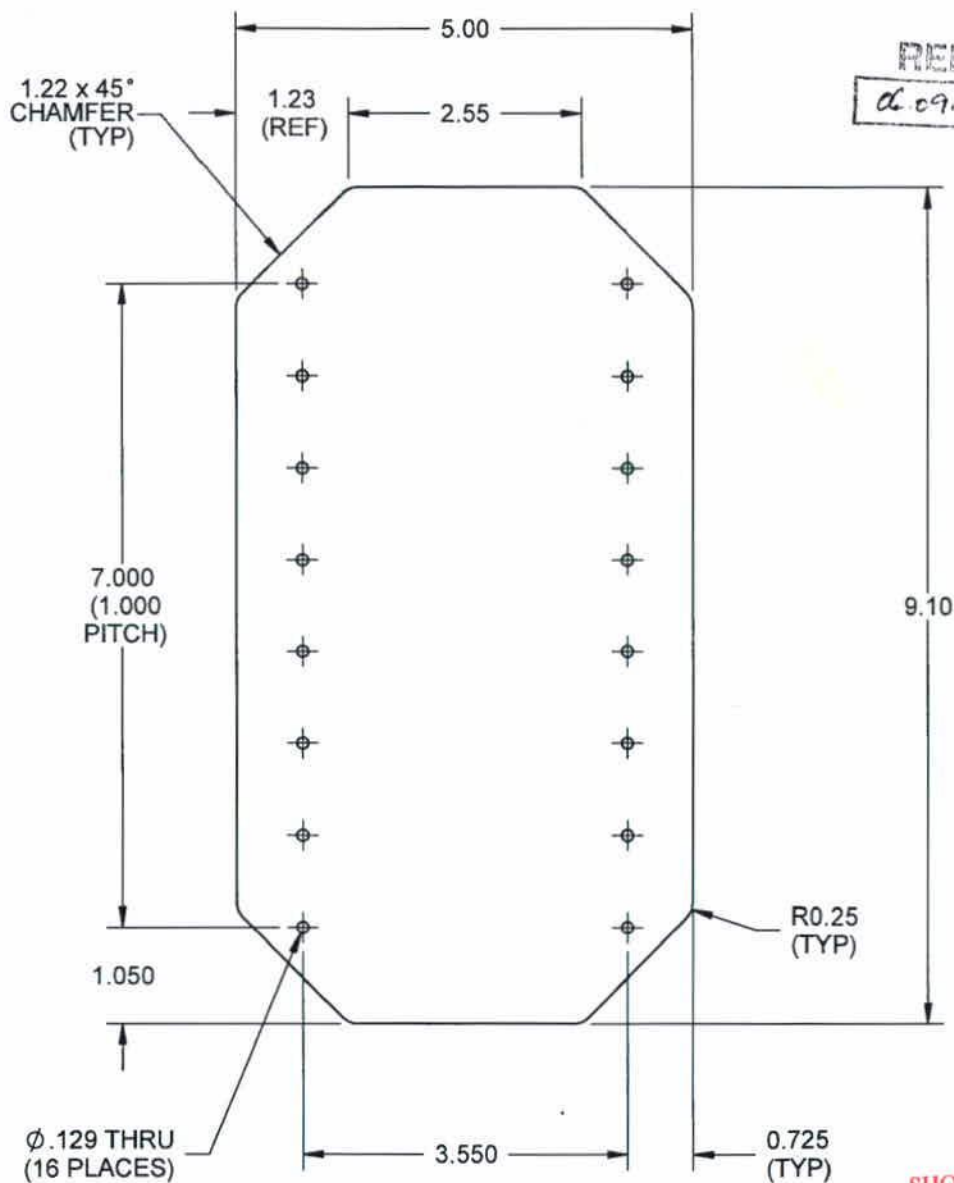
- 1) FINISH: POWDER COAT ASSEMBLY GREY SANDTEX (4.3.5.6) PER DART QSI 005 4.3
- 2) TOLERANCES ARE PER DART QSI 018 UNLESS OTHERWISE NOTED
- 3) ALL DIMENSIONS ARE IN INCHES UNLESS OTHERWISE NOTED

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DATE 06.08.17		TITLE HEAD REST	SCALE 1:2

**D3303-1 PLATE****NOTES:**

- 1) MATERIAL: 2024-T3 (QQ-A-250/4) 0.032 THICK SHEET
(REF. DART SPEC. M2024T3S.032)
- 2) FINISH: CHEMICAL CONVERSION COAT AS PER DART QSI 005.4.1
- 3) TOLERANCES ARE PER DART QSI 018 UNLESS OTHERWISE NOTED
- 4) ALL DIMENSIONS ARE IN INCHES UNLESS OTHERWISE NOTED
- 5) BREAK ALL SHARP EDGES 0.005 TO 0.015

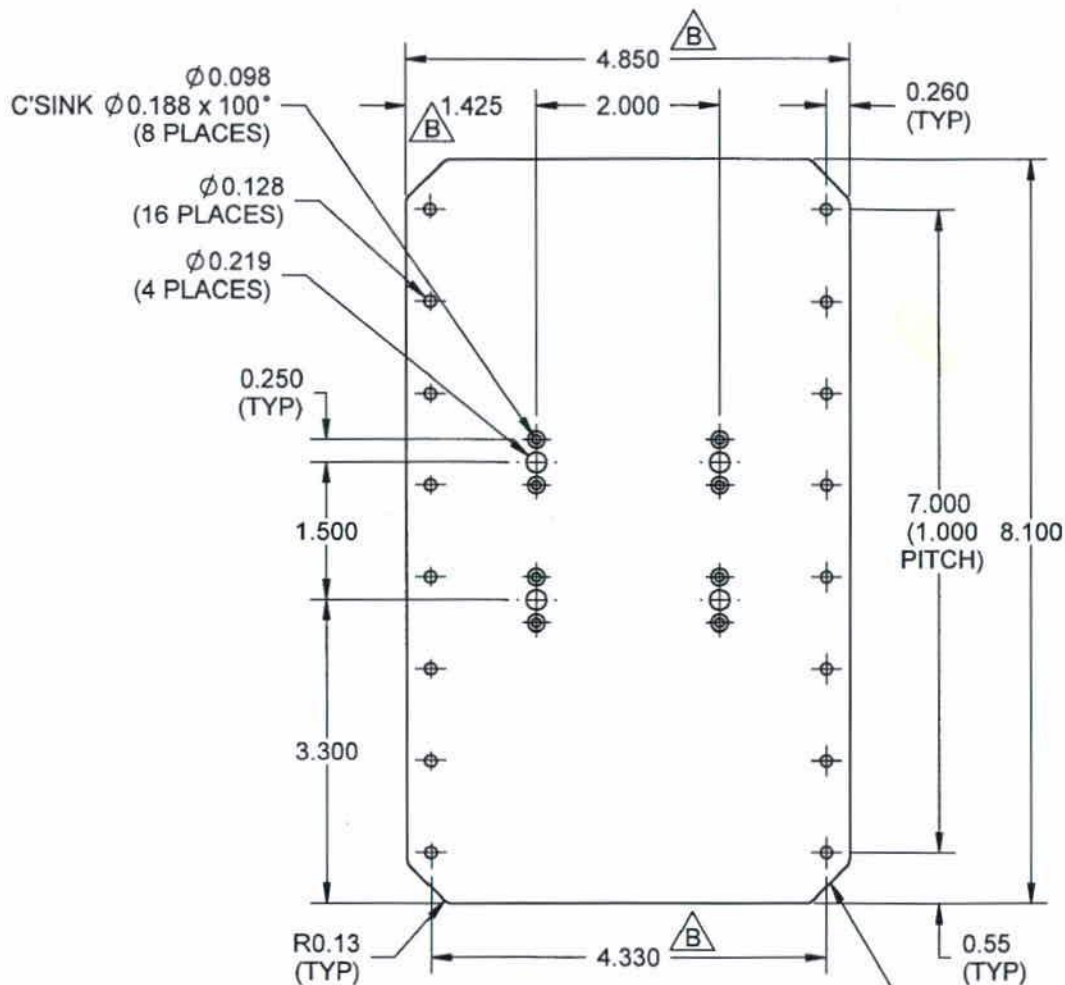
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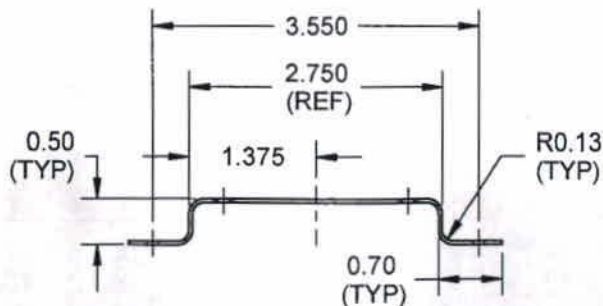
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DATE 06.08.17		TITLE HEAD REST	SCALE 1:2



D33303-3F BRACKET FLAT PATTERN

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06.09.19

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D33303-3 BRACKET BEND DETAIL

NOTES:

- 1) MATERIAL: 2024-T3 (QQ-A-250/4) 0.040 THICK SHEET (REF. DART SPEC. M2024T3S.040)
- 2) FINISH: CHEMICAL CONVERSION COAT AS PER DART QSI 005.4.1
- 3) TOLERANCES ARE PER DART QSI 018 UNLESS OTHERWISE NOTED
- 4) ALL DIMENSIONS ARE IN INCHES UNLESS OTHERWISE NOTED
- 5) BREAK ALL SHARP EDGES 0.005 TO 0.015

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